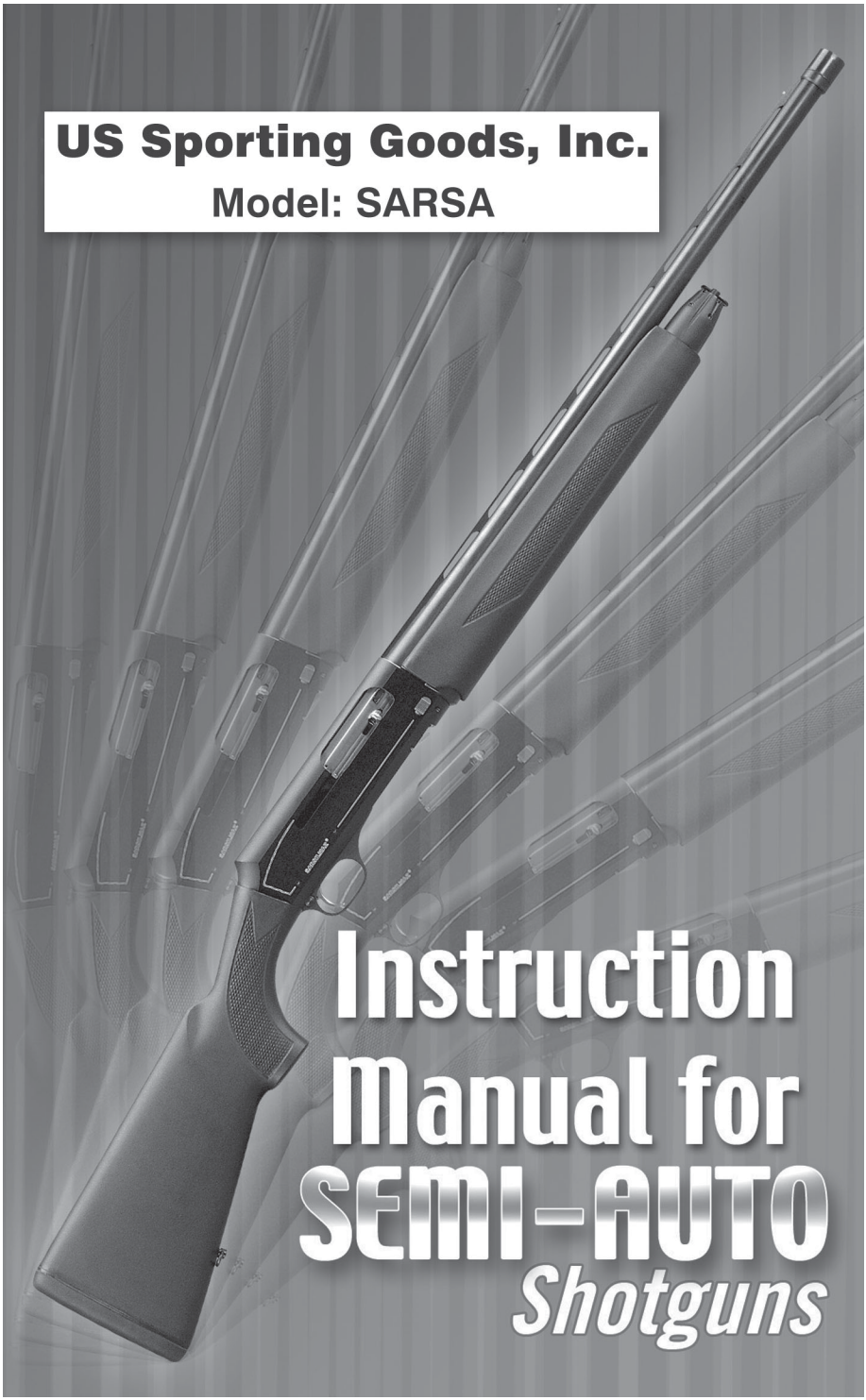
US Sporting Goods, Inc.

Model: SARSA



Instruction Manual for SEMI-AUTO *Shotguns*

FIREARMS SAFETY

Safe firearms handling is the most important consideration of anyone who uses firearms and ammunition. Please take a few minutes to thoroughly read and understand this instruction manual.

You should completely understand this manual before you practice loading, unloading and firing with live ammunition.

Remember, firearms safety does depend on you!

Serial No. _____

Date Purchased: _____

Purchased From: _____

THIS MANUAL CONTAINS

1. Important warnings, which should be read and understood before using this firearm. SAFE GUN HANDLING IS YOUR PERSONAL RESPONSIBILITY AT ALL TIMES. Disregarding warnings in this manual may result in injury or death to you and others and damage to property.
2. Directions and procedures for handling loading, firing and unloading.
3. Instructions for care, cleaning, repair, and service of this shotgun. This instruction and safety manual is designed to help you in learning how to properly use and care for your USSG, INC. shotgun. Only when you are certain you have fully familiarized yourself with the function of your firearm should you practice loading, unloading and firing with live rounds of ammunition. This instruction manual should always accompany this firearm, and be transferred with it upon change of ownership. Should you ever need to replace it, this manual is available FREE upon request from USSG, INC.

DISCLAIMER OF LIABILITY

USSG, INC., shall not be responsible for product malfunctioning or for physical injury, death or damage to property resulting from either intentional or accidental discharge of this firearm, its criminal or negligent use, improper or careless handling, unauthorized modifications or alteration, use of defective or improper or hand-loaded or (replaced) ammunition, or from its use for purposes or subjection to treatment for which it was not designed. For your safety, use only original high quality commercially manufactured ammunition in good condition that is appropriate to the caliber/gauge of your gun. USSG, INC. shall not be responsible for product or its result from use of defective, improper or reloaded ammunition.

WARNING - LEAD EXPOSURE

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances that may cause birth defects, reproductive harm, and other serious physical injury. Have adequate ventilation at all times. Wash your hands thoroughly after exposure, Shooting or cleaning guns may expose you to lead.

WARNING

Prior to removing this gun from its packaging, and prior to loading and firing, carefully and thoroughly read the entire instruction manual which gives advice on the gun's proper handling and functioning. However, your safety and that of others (including your family) depends on your responsible compliance with that advice. If unfamiliar with firearms seek supervised instruction.

FIREARMS SAFETY IS YOUR RESPONSIBILITY.

GENERAL SAFETY WARNINGS

1. Careless and improper handling of this gun could result in unintended discharge causing injury, death or property damage. Safety must be the first and constant consideration when handling a firearms and ammunition.
2. This shotgun was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or replace parts.
3. Shotguns should only be carried with the action open and chambers empty to prevent accidental discharge.
4. **Always handle and treat your gun as if it were loaded** so you never fire it accidentally when you think it is unloaded. Never take anyone's word it is unloaded. Always check it yourself with your fingers off the trigger and the gun pointed in a safe direction.
5. Never place your finger inside the trigger guard unless you intend to fire.
6. Water, snow, mud, excessive lubricating oil or grease or any other material can obstruct the barrel of your gun. Always check the barrel of your firearm for obstruction before loading and firing. Clean a fouled gun immediately to ensure its correct and safe function.
7. **Keep the gun's muzzle pointed in a safe direction at all times.** Never let the muzzle of a firearm point at any part of your body, another person or at anything you do not intend to shoot. Always be certain of your target before firing.
8. **UNLOAD ALL FIREARMS WHEN NOT IN USE, NEVER STORE A LOADED FIREARM.** Firearms and ammunition should be safely stored separately so that they are inaccessible to children or unauthorized users.
9. Always make sure your gun is not loaded before cleaning, storing, or handing it to another person.
10. Always wear safety glasses while shooting to protect your eyes from injury by gun powder, gas, lubricant, dirt or metallic particles, carbon residue, sparks or other debris.
11. Always wear ear protection when shooting, especially on a range. Without ear protection, the noise from your gun, and other guns close to you, could leave a "ringing" in the ears for some time after firing. Repeated exposure to shooting noise could result in permanent hearing loss.
12. Never climb a tree, fence or wall while carrying a loaded firearm.
13. Don't shoot at hard surface, or at water. A pellet may ricochet and travel in unpredictable directions to strike you or an object you cannot see.

14. Firearms and alcohol don't mix. Never drink alcoholic beverages or take drugs before or during shooting, as this constitutes criminal disregard for your safety and that of others. Never use a gun while you are taking medication unless you have checked with your doctor to ensure your fitness to handle your gun safely.
15. If you have any doubts about your ability to handle or use this shotgun safely, seek supervised instruction.
16. Horseplay has no place around firearms. Guns can't think- you can!
17. Remember, safety is your responsibility, be a safe shooter.
18. FOLLOW THE LAW: Obey all local, state and federal laws regarding storage, shooting and transporting your firearm.

FOLLOWING THESE SAFETY RULES CAN SAVE YOUR LIFE OR THE LIFE OF SOMEONE ELSE

Get instructions from a competent firearms instructor before using this or any firearm. Learn from a professional how to handle, load, unload, operate, fire and care for your gun.

NEVER PLAY with your firearm. It is not a toy and can be a very dangerous weapon that can cause serious personal injury or death.

Always keep the gun pointed in a safe direction. Treat every gun as if it is loaded...all the time. **NEVER** point any firearm (loaded or unloaded) at any person or anything you do not intend to shoot. Always keep your gun unloaded until ready to use and make sure that it is unloaded before cleaning.

Keep your finger **OFF** the trigger until you are actually aiming at the target and ready to shoot. Learn to rest your finger outside of the trigger guard.

Never rely on a gun's "safety" to protect you from unsafe gun handling. A safety is only a mechanical device, not a substitute for using common sense and following gun safety procedures.

Never leave a gun unattended or where it could fall.

Store guns and ammunition separately **beyond the reach of children**. Make sure that they are properly secured so untrained individuals and children will be denied access to your guns and ammunition.

Test your gun's operation and safeties only at a shooting range while the firearm is pointed in a safe direction.

Know your target and what is beyond. Ask yourself what the projectile will hit if it misses the target or passes through the intended target. Remember, a fired projectile can travel over a mile (including a ricochet) and is capable of going through walls. Never shoot at hard flat surfaces or water. . .bullets ricochet.

FOLLOWING THESE SAFETY RULES CAN SAVE YOUR LIFE OR THE LIFE OF SOMEONE ELSE

Guns and alcohol or drugs do not mix. Don't take any alcoholic beverages and/or drugs before or during shooting activities.

Never pull a gun toward you by the muzzle. Don't climb a tree, cross a ditch or fence with a loaded gun.

Always empty guns before entering a house, car, truck, boat, RV, camp or any building.

When receiving a gun, always open the action and check to make sure the chamber is unloaded.

NEVER accept anyone's word that a gun is "unloaded" or "empty." You should immediately open the action and check to make sure it is unloaded.
Be careful with **ALL** ammunition. Even "blank" cartridges are deadly at close range due to the muzzle blast. Make sure your ammunition is new and in good clean condition. Do **NOT** oil or grease ammunition as this may damage the cartridge primer. Do **NOT** tamper with or alter the standard factory ammunition.

Keep firearms unloaded when not actually in use. Load the gun only when on the range preparing to fire and unload it before leaving the range.

Never put your hand over the muzzle of a gun.

ALWAYS WEAR protective shooting glasses and hearing protection when using firearms.

Spectators should be at least 10 feet behind and away from the shooter while the shooter is loading, shooting and unloading. Spectators should wear protection for hearing and sight loss and they should avoid distracting those shooting their firearms.

Never drop your gun. If you do drop it, unload it and check it for proper function before using it again.

Do **NOT** alter or modify your gun. Don't try to change your gun's trigger pull, because it may affect sear engagement and thereby cause accidental firing.

Do **NOT** remove any internal safety or safety device on the firearm. Safety mechanisms are designed to help protect you from injury or death.

Properly maintain and keep your gun clean. Keep it in a dry place away from other metals and water. If your gun shows sign of corrosion or improper operation, have it serviced by a competent gunsmith.

Keep the muzzle pointed in a safe direction when loading and unloading your gun. Never point the muzzle at anyone. Never put your hand over the muzzle of a gun.

FOLLOWING THESE SAFETY RULES CAN SAVE YOUR LIFE OR THE LIFE OF SOMEONE ELSE

If a gun fails to fire when the trigger is pulled, keep it pointed down range at the target for 60 seconds. Sometimes slow primer ignition will cause a “hang fire” and the cartridge will go off after a short pause. If it still fails to fire, keep muzzle pointed in safe direction and avoid exposure to the breech, as you attempt to unload your firearm.

Never let water, snow, mud or other material enter the barrel. Always be sure the barrel is free of any obstruction.

Use the correct ammunition for your gun. Do **NOT** use the wrong size or wrong strength ammunition in your firearm.

Teach children: 1. NOT to touch guns, bullets, cartridges, shells, flares or any explosive device and **2.** That if they discovery such a dangerous item or weapon, they must immediately report its location to their parents, school teacher or police.

Remember a firearm has the capability of taking your life or the life of someone else. Be careful with your firearm — an accident is almost always the result of not following basic safety rules.

USED FIREARMS - Firearms are sometimes altered to work incorrectly, or parts may be removed, lost or replaced with incorrect parts. If you got your USSG INC. firearm as a used gun, **BEFORE USING IT** you should take it to a good gunsmith who knows USSG INC. firearms, and have him examine it.

WRITE USSG INC. concerning any items or circumstances which you don’t understand and which might relate to your safety and the operation of your firearm at: USSG INC., 411 HAWK St, Rockledge, FL 32955 (321) 639-4842.

W A R N I N G (POTENTIAL OBSTRUCTIONS)

BEFORE LOADING or firing a shotgun, examine the bore and the firing chamber to be certain they are clean and free of any obstruction. Even a heavy coat of oil, grease, snow or water may result in damage to the firearm and injury to the shooter and/or persons near the firearm. A misfire or unusual sound upon firing is a signal to cease firing and to examine the chamber and bore. If there is any obstruction, clear the obstruction and clean the bore and chamber before firing.

Any bore obstruction, even if it is only partly blocked, may cause the gun to blow up if it is fired, or may cause damage to the gun such as a bulged barrel. To avoid injury or death to the shooter or bystanders, check the barrel before shooting or if a shot does not sound normal.

W A R N I N G

Always keep the muzzle pointed in a safe direction! Never attempt to load or unload any firearm inside a vehicle, building or other confined space (except a properly constructed shooting range). Enclosed areas frequently offer no completely safe direction in which to point the firearm. If an accidental discharge occurs, there is great risk of death, personal injury or property damage. Before loading, always clean all, grease and oil from the bore and chamber, and check to be certain that no obstruction is in the barrel. Any foreign matter in the barrel could result in a bulged or burst barrel or other damage to the firearm and could cause serious injury to the shooter or to others.

W A R N I N G

If there is any reason to suspect that a projectile is obstructing the barrel, immediately unload the firearm (See Unloading Instructions) and check the chamber and the bore. A wad, shot or some other matter may be lodged some distance down the barrel where it can not easily be seen. Check the bore by using a cleaning rod to pass through the barrel. If a blockage is in the bore, **DO NOT ATTEMPT TO SHOOT IT OUT WITH ANOTHER CARTRIDGE, OR BLOW IT OUT WITH A BLANK CARTRIDGE OR A CARTRIDGE FROM WHICH THE SHOT HAS BEEN REMOVED. SUCH TECHNIQUE(S) CAN GENERATE EXCESSIVE PRESSURE, DAMAGE THE FIREARM AND CAUSE SERIOUS PERSONAL INJURY**. If the blockage can be removed with a cleaning rod, clean any unburned powder grains from the bore, chambers and mechanism before resuming shooting. If the blockage can not be dislodged by tapping it with a cleaning rod, take the firearm to a gunsmith.

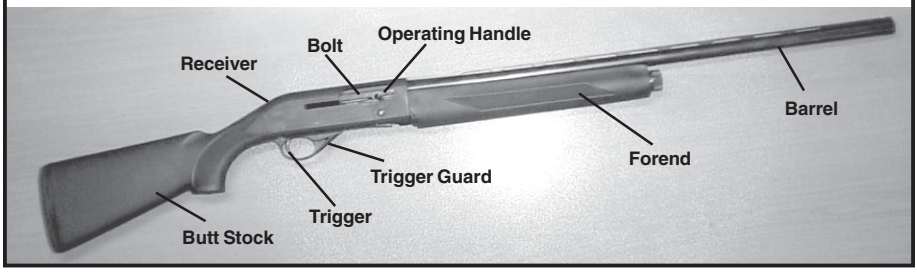
W A R N I N G (EYE AND EAR PROTECTION)

When shooting, full eye and ear protection is mandatory at all times. Shooters and spectators must wear shooting glasses and hearing protection to prevent eye injury and hearing loss. Vision and hearing impairment can occur with only one moment of non-protection.

WARNING (Mechanical Malfunctions)

STOP SHOOTING IMMEDIATELY AND UNLOAD YOUR FIREARM if your firearm develops: a mechanical malfunction; binding or stoppage; spitting powder/gas; a cartridge primer is punctured; a cartridge case is bulged or ruptured; or the sound on firing does not sound quite right. Do **NOT** try one more shot but unload your firearm and take it and the ammunition to a qualified gunsmith or send the firearm back to USSG INC. for examination. Do not assume that the shotgun is empty merely because you checked the chamber. You must also check the bore for any fired shot or wad jammed inside the barrel.

MODEL SARSA NOMENCLATURE



DIRECTIONS FOR ASSEMBLY

WARNING

Read and understand all instruction and warnings in this manual BEFORE using this shotgun. It is important to learn the parts of your shotgun and their functions before using this firearm.

Fig. 1

UNPACKING YOUR SHOTGUN

When you remove the shotgun from its box, you will see the 2 major components shown above, the barrel and the shogun **(Fig. 1)**. Your shotgun should come with 3 choke tubes, one installed in the barrel and 2 extra tubes, along with a choke tube wrench.

MANUAL SAFETY

Your shotgun is equipped with a manual trigger block safety button located in the trigger guard, just behind the trigger. When the button is pushed from the left side of the receiver, protruding to the right side, the trigger is blocked and the safety is on as shown in **Fig. 2**. When the button is pushed from the right side of the receiver, protruding to the left side, you will see a red circle on the safety button indicating the safety is off and the shotgun is in an unsafe condition, ready to fire if the trigger is pulled, as shown in **Fig. 3**.

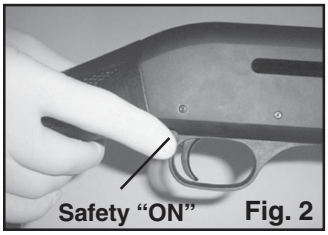


Fig. 2

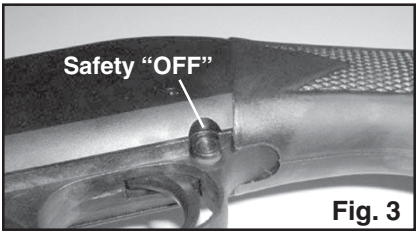


Fig. 3

WARNING

The manual safety of your shotgun should always be on except for when you are ready to pull the trigger and fire the shotgun. This will help insure that no accidental discharges take place. You should only have the safety off, and be able to see the red line on the left side of the receiver, when you are ready to shoot.

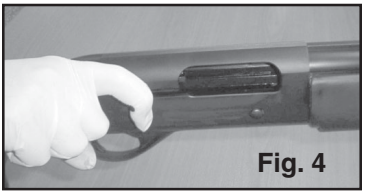


Fig. 4

DIRECTIONS FOR ASSEMBLY

Holding the shotgun as shown in **(Fig. 4)**, use your finger(s) to pull the bolt handle fully to the rear until the bolt locks in its open position. Unscrew the magagine cap from the front of the forend in a counter clockwise direction as shown in **Fig. 5**.

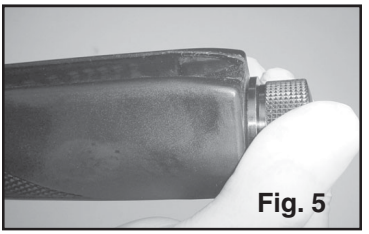


Fig. 5

Remove the forend by sliding it forward, off the shotgun as shown in **Fig. 6**. Note that the forend may be tight to the shotgun when doing this.

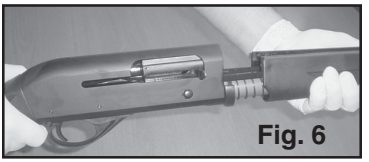


Fig. 6

In order to properly insert the barrel into the receiver it is necessary to release the bolt from its locked position in the receiver. As the bolt is under spring tension, care must be given to properly releasing the bolt so that components do not come off the end of the magazine tube during this procedure. In **(Fig. 7)**, you will see the location of the action release button. Refer to **(Fig. 8)**. While holding the bolt handle with your right hand, depress the action release button with your finger and allow the bolt to go forward slowly with your right hand until the bolt handle reaches the end of the receiver.

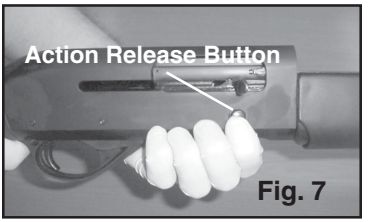


Fig. 7

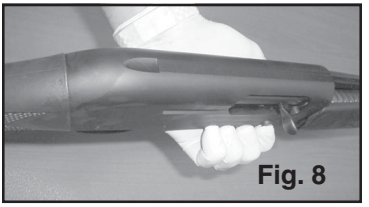


Fig. 8

Carefully align the barrel with the receiver and the end of the magazine tube, as shown in **(Fig. 9)** and begin to pull back on the bolt handle as you insert the barrel into the receiver.

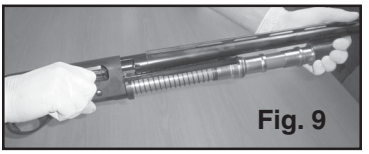


Fig. 9

Continue pulling the bolt handle back while inserting the barrel until the bolt is in its rear locked position and the barrel is completely seated in the receiver.

The barrel should mate to the receiver at this point in the assembly as shown in **Fig. 10**.

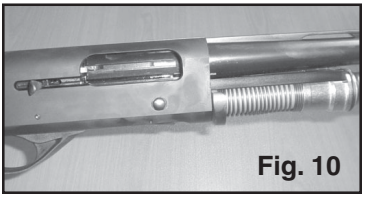


Fig. 10

Slide the forearm over the magazine tube assembly as shown in **(Fig. 11)**, bringing it to rest against the receiver. There are two holes in the forend that will align with the small pins in the front end of the receiver. The forearm is in its proper position when it is seated completely against and around the receiver as shown in **Fig. 12**.

Reattach the magazine cap to the magazine tube by rotating it in a clockwise direction until it is firmly screwed down against the forearm as shown in **(Fig. 13)**. The shotgun is now completely assembled. To close the bolt/action, depress the action release button on the right side of the receiver as shown in **(Fig. 14)**. Check, to be sure no fingers or other objects are located near the bolt as it closes. Put the safety in the "ON" position!

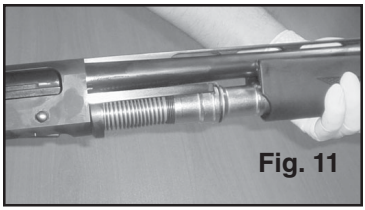


Fig. 11

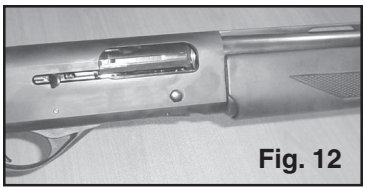


Fig. 12

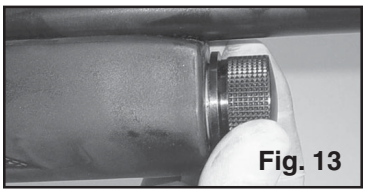


Fig. 13

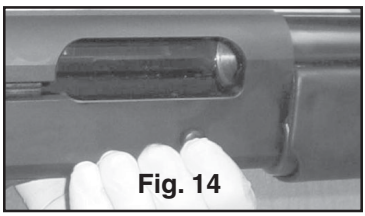


Fig. 14

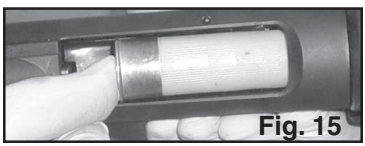


Fig. 15

CAUTION

Do not load your shotgun until you are ready to use it and unload it immediately after you have finished shooting. Always carry your shotgun with the safety engaged. The user of this shotgun, and all firearms, should never depend on the manual safety, or any other mechanical device, to make a firearm completely safe. It is your responsibility to always keep the muzzle of your firearm pointed in a safe direction.

LOADING

When loading, keep the safety on at all times and keep the muzzle pointed in a safe direction. To load the magazine tube, draw back the operating handle until it's locked in the open position, press the action release button once and turn the shotgun upside down. This will allow the cartridge lifter to move into the receiver well. Insert your cartridge and push it into the magazine tube until it is held in place in the tube by the cartridge latch. As you insert each cartridge you will hear a "click" that tells you the latch has closed behind the cartridge and you can now load the next shell. See **(Fig.15)**. The action release button should be held in while loading or it will have to be depressed after each cartridge is loaded.

Note: Your shotgun is equipped with a plug that limits the number of cartridges that your magazine tube will hold to 2 shells. Removal of the plug is shown in this manual in the DISASSEMBLY section.

To load a cartridge into the chamber, pull back on the bolt handle. As you pull the bolt handle fully rearward, a cartridge will come out of the magazine tube and the cartridge carrier will raise the shell aligning it with the chamber. Release the bolt handle and the forward travel of the bolt will chamber the first round. See **(Fig.16)**. Never allow your fingers or another object to come in contact with the trigger while loading.

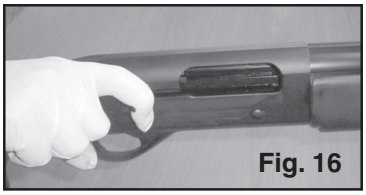


Fig. 16

Your shotgun is now loaded and ready to fire if the safety is moved to the OFF position. To fire the shotgun, hold the shotgun firmly with both hands and the proper placement of the buttstock toy our shoulder and cheek. Aim at your target. Press the safety button into the OFF position and pull the trigger. The system that operates your semi-auto will fire the cartridge in the chamber, eject the fired case and load the next cartridge into the chamber, each time that you pull the trigger. Be prepared to either fire your next shot or engage the safety in to ON position after firing.

UNLOADING

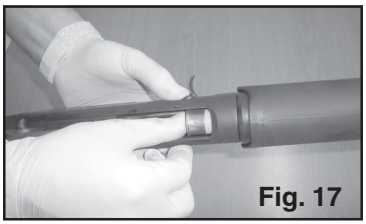


Fig. 17

Before unloading, make sure the safety is in the ON position. And keep the muzzle pointed in a safe direction. Never allow your fingers or another object to come in contact with the trigger during unloading. Push action release button then push carrier; after pushing the action release button, the cartridge will be ejected from magazine tube. See **(Fig. 17)**. After emptying magazine tube, pull the bolt handle completely to the rear and this will eject any cartridge that is remaining in the chamber. Visually check to make sure that no cartridges may be remaining in the chamber or magazine tube and depress the bolt release button to close the action/bolt.

Interchangeable Choke Tubes

All USSG, INC. semi-auto hunting type shotguns, except slug models, come with tubes and a choke tube wrench.

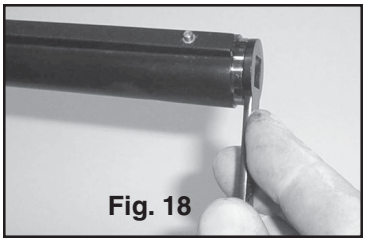


Fig. 18

Your VR-MC barrel is threaded for your choke tubes. For internal tubes, insert the wrench into the slotted portion of the tube and turn counterclockwise to remove it from the barrel and turn clockwise to install it. **Fig. 18 & 19**. For external tubes, simply grasp the knurled end of the tube and twist it off or on as necessary.

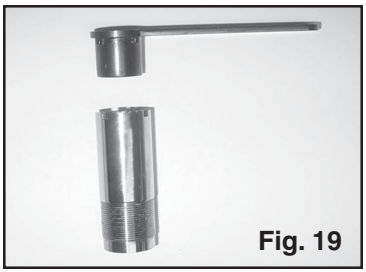


Fig. 19

WARNING
When installing a choke tube in your barrel, make sure that the tube is completely screwed down tight is the barrel, never discharge your shotgun without the choke tubes installed as this may damage the barrel. Choke tubes may become loose after extended firing and should be checked frequently for tightness.

STEEL SHOT WARNING
Steel shot shells should only be used with modified tubes or tubes with less constriction than modified tubes.

Choke Tube Markings
Your internal interchangeable choke tubes are marked with notches at the end of the tubes to indicate the choke type for that particular tube. Your external tubes are marked just below the knurled rim of the tube.
Please refer to the chart below to identify which chokes are supplied with your shotgun. Chokes shown in the chart that are not supplied with your shotgun are available from our part department.

Semi-Auto & Pump Shotgun Multi-Choke Tube Markings and Constrictions

INTERNAL TUBES	
Name	**Notches**
Cylinder	IIIII
Improved Cylinder	IIII
Modified	III
Improved Modified	II
Full	I

EXTERNAL/EXTENDED TUBES	
Name	**Markings**
Cylinder	CYL
Improved Cylinder	IC
Modified	M
Imrpoved Modified	IM
Full	F

DISASSEMBLY

Before disassembling your shotgun, be absolutely certain that it is unloaded. As an added precaution, visually check the chamber and the magazine tube for any cartridges. Put the safety in the on position. Pull the bolt handle to its full rearward position, locking the action open. Remove the magazine tube cap by unscrewing it counter clockwise, **Fig. 20**.

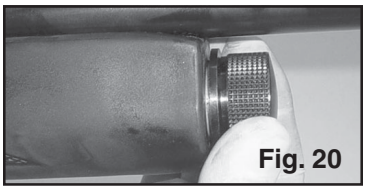


Fig. 20

Remove the forearm by sliding it away from the receiver and off the end of the magazine tube, **(Fig. 21)**. Remove the barrel by pulling

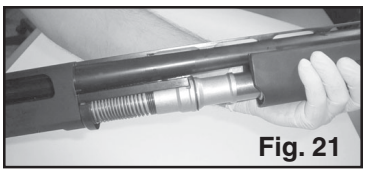


Fig. 21

the barrel out of the receiver assembly and out from around the magazine tube. Releasing the action may assist you in removal of the barrel, see **Fig. 22**.

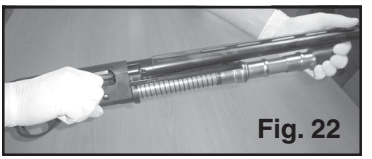


Fig. 22

Fig. 23

Remove the 0 ring, **Fig. 23.**

Fig. 24

Remove the gas piston, **Fig. 24.**

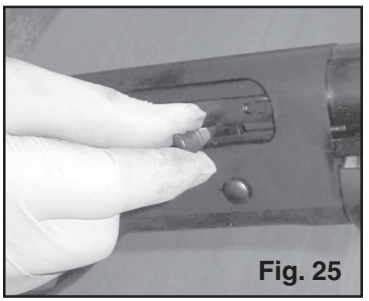


Fig. 25

You can remove the bolt handle by moving the action bar rearward under spring tension with your left hand, until the bolt moves enough for you to align it with the cut out hole in the bolt that receives the handle. At this point, the bolt handle can be freely removed from the bolt. See **(Fig. 25)**. Remember that the bolt is still under tension from the spring.

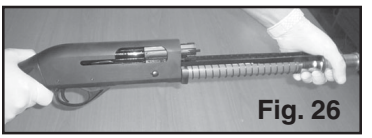


Fig. 26

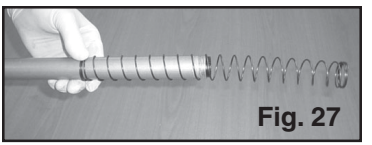


Fig. 27

After you remove the bolt handle, the entire action bar/bolt assembly can be removed from the shotgun by pulling the action bar off the end of the magazine tube. See **Fig. 26.**

Remove the magazine spring from around the magazine tube, **Fig. 27.**

The action bar, action bar sleeve and bolt assembly can be separated for cleaning. Lift the bolt off the action bar by simply pulling it up and off the bar, **Fig. 28.**

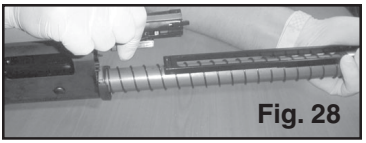


Fig. 28

Separate the action bar from the action bar sleeve by pulling the action bar up and away from the action bar sleeve as shown in **Fig. 29.**

Fig. 29

The trigger group may be removed from the receiver for further cleaning of the receiver and trigger group. It is recommended that a thorough cleaning be performed every 300 rounds.

To remove the trigger group, first remove the two trigger group retaining pins by using a punch to drive the pins out of the receiver, **Fig. 30.**

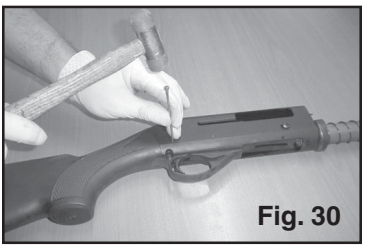


Fig. 30

Once the retaining pins are removed, the entire trigger group can be removed from the receiver by pulling down on the trigger guard, **(fig. 31)**. No further disassembly of the trigger group is recommended for anyone other than a trained gunsmith.

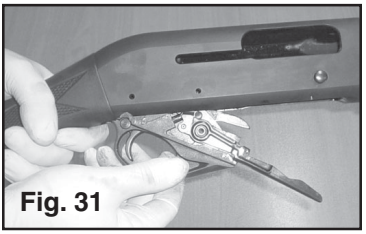


Fig. 31

Note: When reinstalling the trigger group, the hammer must be in its cocked position. To cock the hammer, pull down on the hammer with your thumb until it locks into place as shown in **fig. 32**.

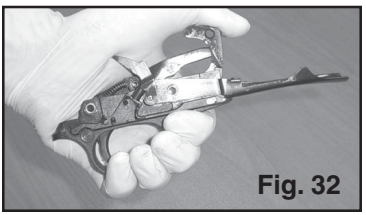


Fig. 32

Magazine Capacity Plug

Your shotgun is supplied with a plug to limit the capacity of cartridges in the magazine tube. Your state may not require this plug to be used so it may be removed. When the barrel has been removed from the shotgun, insert a large bladed screwdriver into the hole in the magazine spring retainer, **Fig. 33.**

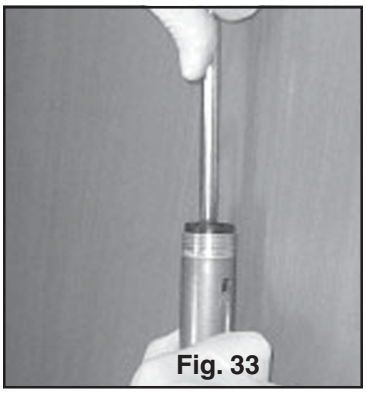


Fig. 33

Insert a flat screwdriver into magazine spring retainer and depress tab as per **(Fig. 34)**. Be very careful at this point, as the retainer is holding a spring inside of the magazine tube and the spring is under tension. Slowly pull back on the screwdriver to allow the magazine spring to push the retainer and capacity plug out of the magazine tube. Remove the plastic plug from the tube and reassemble the retainer plug back into the magazine tube. Be careful, as the spring will be under tension. Align the cutout of magazine tube with the detent on the magazine spring retainer and push the plug into the tube and rotate spring retainer until the tab on the retainer snaps into the oval hole cut out of the magazine tube. See **Fig. 35**.

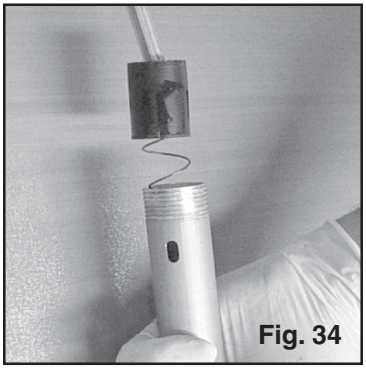


Fig. 34

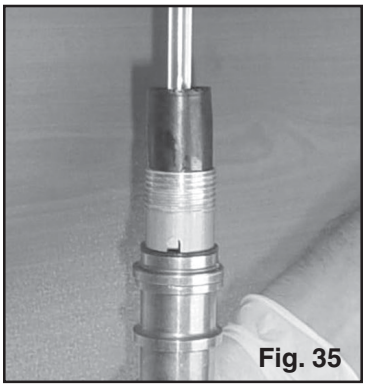


Fig. 35

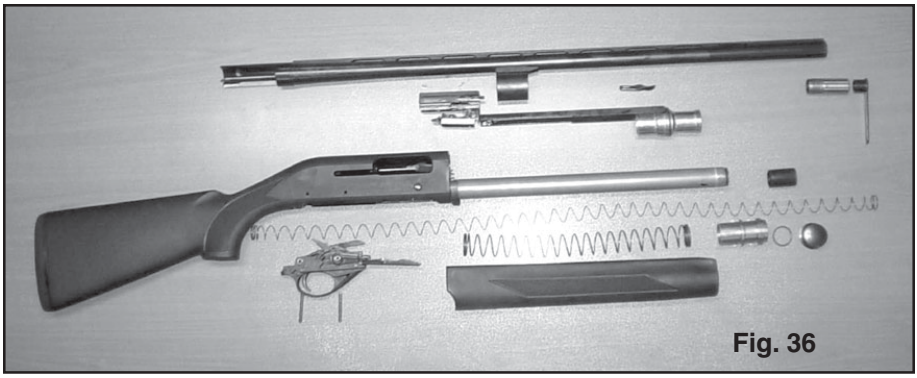


Fig. 36

Note: Your shotgun has now been completely disassembled. No further disassembly of your shotgun is necessary for routine maintenance and cleaning. Our service department or a competent gunsmith should only perform any further disassembly. An exploded view of the disassembled shotgun is shown in **Fig. 36.**

Note: This manual was prepared to include instructions for all semi-auto shotguns, 12 gauge 3" models, 12 gauge Maxi-Mag models (31/2"), or 20 gauge 3" models. Photographs shown in this manual may not be from the exact model that you have but the instructions will apply to the model that you have.

GAS PISTON INSTALLATION

Your shotgun is supplied with a reversible gas piston for firing light and standard loads or heavy and magnum loads. For firing light or standard loads with 23/4" shells, the gas piston should be installed on the magazine tube as shown in **(Fig. 37)**. When firing magnum 23/4" or all 3" shells, the piston should be installed as shown in **(Fig. 38)**. When firing magnum loads with the piston in the correct direction, the felt recoil and wear on the gun will be minimized.

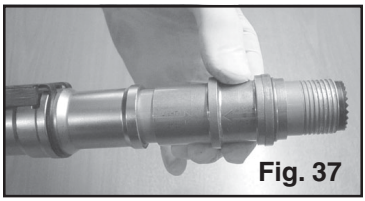


Fig. 37

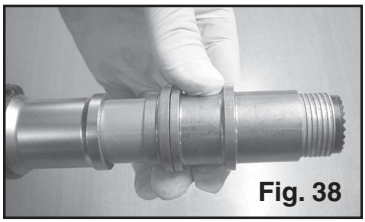


Fig. 38

AMMUNITION

Each USSG, INC. semi-auto shotgun is clearly marked with the gauge and maximum length cartridge that may be used in that particular model. Barrels marked **12 GA 3"** will shot 12 gauge 23/4" and 3" shells. Barrels marked **20 GA 3"** will shot 23/4" and 3" shells. Maxi-Mag models with barrels marked **12 GA 31/2"** will handle all 12 gauge 31/2" Magnum shells, 12 gauge 3" Magnum shells, 12 gauge 23/4" Magnum shells and all 12 gauge 23/4" hi-brass shells loaded with a minimum 36 gr. of lead shot.

Do not use a cartridge that is longer than the maximum cartridge length that is stamped on the barrel.
The use of reloaded or substandard commercially produced ammunition will affect your warranty coverage and could result in severe injury to the shooter or other nearby. See the enclosed warranty registration card for any exclusions and limitations of our warranty.

WARNING

The accidental loading and discharge of shells of the wrong gauge in your gun can result in damage to your gun and possible injury or death to you or others. To be safe at all times, carry only the proper gauge ammunition with you for the gun you are using.

CLEANING AND STORAGE

After extended shooting sessions, it will be necessary to clean your shotgun. Semi-auto shotguns require more cleaning than any other type of shotgun, because of their gas operated construction. Periodically, clean the bore with proper cleaning equipment. Oil all metal surfaces lightly with high quality gun oil. Never pour oil into any inside mechanisms. If you will be storing your shotgun for long periods of time, apply gun grease to all metal parts, store the shotgun in a dry, and secure area. When you clean the shotgun, make sure the muzzle is not plugged with any heavy grease that would cause a barrel obstruction.

MANUFACTURER'S WARNING:

This firearm was manufactured to properly perform with the original parts as designed. It is your duty to make sure any parts you buy are correctly installed and that neither replacements nor originals are altered or changed. Your gun is a complex tool with many parts that must relate correctly to other parts for safe and accurate operation. Putting a gun together wrong or with modified parts can result in a damaged gun, or personal injury or death to you or others. Always let a qualified gunsmith work on your gun or at least, check any work not performed by a gunsmith. Firearms safety is your primary concern. **THE GUN OWNER MUST ACCEPT FULL RESPONSIBILITY FOR THE CORRECT REASSEMBLY AND FUNCTIONING OF THE FIREARM AFTER ANY DISASSEMBLY OR REPLACEMENT OF PARTS.**

TO CLEAN AND MAINTAIN YOUR SHOTGUN:

A) Follow procedures for unloading shotgun as described previously.

B) Follow procedures for disassembly of shotgun as described previously.

C) Materials needed to clean this shotgun are: a cleaning rod, cotton bore patches, brass bore brush, powder solvent, a small soft brush and good quality gun oil.

WARNING: Lead or lead compounds are known to the State of California to cause cancer, birth defects, reproductive toxicity, and other serious physical injury. Those who clean firearms should take protective measures to avoid contact or exposure to such chemicals.

D) Using the bore brush with powder solvent, scrub the interior of the barrel and chamber to remove any powder and lead residue in the bore. Always and lastly, swab the interior of the barrel with cotton patch with gun oil to coat and protect the bore and chambers from rust and corrosion.

E) Any powder fowling on the firing wall, barrel, etc. can be easily cleaned with a brush and powder solvent.

F) All external surfaces should be wiped down with a light coat of rust preventative. Avoid using too much oil as powder, dust or other foreign material may get trapped in the oil. This could lead to congealed deposits which may interfere with the safe and reliable operation of the shotgun.

G) USE CAUTION while using solvents in gun bore cleaning. Prolonged or excess contact with solvents can damage the gun's bluing and finish. Be sure to wipe away all excess solvent and then lubricate with oil.

H) A gun should be cleaned after firing. In addition, external parts should be wiped with an oiled cloth after handling. A light oil is ordinarily all that is necessary in cleaning if the gun has not been fired or fired very little. If a gun is used frequently, it must be cleaned after each firing and regularly serviced by a professional gunsmith. If the gun has been stored, remove all excess oil and/or grease before firing. Always check to be sure that no cleaning patch or other obstruction remains in the bore or chambers before firing.

DANGER — AMMUNITION WARNING

Firearms may be damaged and serious personal injury or death to the shooter or bystanders may result from any condition which contributes to the generation of excessive pressure or uncontrolled release of gas within the firearm. Such adverse conditions can be caused by bore or chamber obstructions, propellant powder overloads or by defective, incorrect or improperly loaded and assembled cartridge components. Even the strongest firearm can be blown up as a result of excessive pressure. It is extremely dangerous to use a cartridge whose pressure is greater than that developed by cartridges loaded to industry standards.

AMMUNITION (CARTRIDGES) NOTICE

We specifically disclaim responsibility for any damage, injury or death occurring in connection with or as the result of the use of USSG INC. shotguns with faulty, non-standard, remanufactured, hand loaded or reloaded ammunition or with cartridges other than factory cartridges for which the firearm was originally chambered.

LUBRICATION WARNING

Firing a shotgun with oil, grease or any other material even partially obstructing the bore may result in damage to the shotgun and personal injury to the shooter and those nearby. Do not spray or apply lubricants directly on ammunition. If the powder charge of a cartridge is affected by the lubricant, they may not fully ignite yet the energy from the primer and/or powder may still be sufficient to push the projectile or wad into the bore where it may become lodged. Firing a subsequent cartridge into the obstructed bore will damage the shotgun and may cause personal injury to the shooter and those nearby. Use lubricants properly. You are responsible for the proper care and maintenance of your firearm and ammunition.

ONE YEAR LIMITED WARRANTY

This USSG INC. firearm is warranted to the original retail customer for One Year from date of purchase against defects in material and workmanship. All parts and labor or replacement **at our option** are covered. Stock and Fore End are not covered by the One Year Warranty. The warranty on the stock and fore end is 60 days from purchase and only covers manufactured and material defects.

Transportation to and from our repair facilities, government fees, damage caused by failure to perform normal maintenance, sales outside the United States, damage due to use of high velocity, high pressure, reloaded or other nonstandard ammunition, or any unauthorized repair, modification, misuse, abuse, or alteration of the product is not covered by this Limited Warranty.

Any implied warranties, including the implied warranties of merchantability and fitness for a particular purpose, are limited to one year from date of original retail purchase. Consequential or incidental damages and/or expenses, or any other expenses are not covered by this warranty.

To obtain warranty performance send your firearm with proof of retail purchase, freight prepaid to:

USSG INC.
411 HAWK St
Rockledge, FL 32955

NOTICE: It is illegal to ship a firearm with ammunition in the firearm or in the same packaging. Firearms and ammunition must be shipped separately. For information about shipping ammunition, call USSG INC. at (321) 639-4842.

WARNING—ALTERATIONS OR MODIFICATIONS

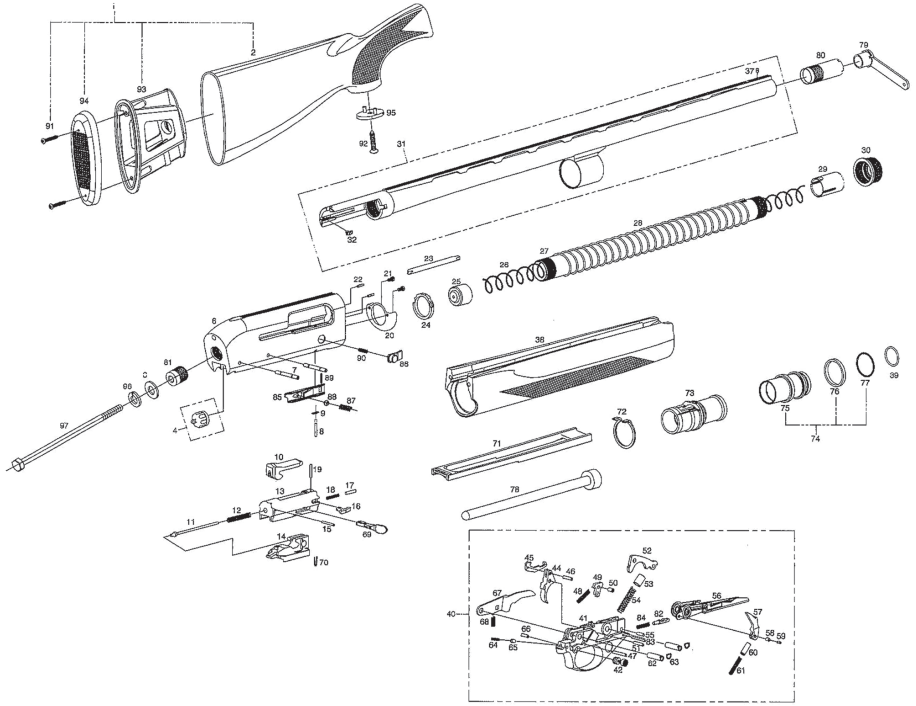
Altering or modifying parts and/or internal safeties is dangerous and will void the warranty. This shotgun was manufactured to perform properly with the original parts as designed. It is your duty to make sure any parts you buy are made for this firearm and are installed correctly and that neither the replacements nor originals are altered or changed. Your gun is a complex precision tool with many parts that must relate correctly to other parts in order for proper and safe operation. Putting a gun together wrong or with incorrect or modified parts can result in a damaged gun, danger, and personal injury or death to you and others through malfunction. Always have a qualified gunsmith work on your gun or at least check any work not performed by a gunsmith.

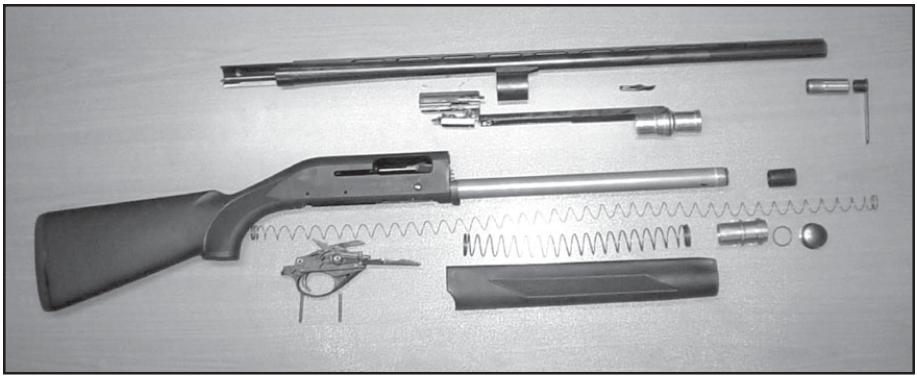
YOUR OWNER'S MANUAL

Always keep this manual with your firearm. Make sure you understand all the warnings, operation instructions and safety procedures. When you lend, give or sell the firearm, be sure this manual goes with it. You can get a copy of this manual from USSG INC. upon request.

ALL PARTS ORDERS ARE SUBJECT TO A $10.00 CHARGE FOR SHIPPING AND HANDLING. Please state Model, Caliber, Serial Number, and Finish Color when ordering. For parts, information and service contact: USSG INC., 411 HAWK St, Rockledge, FL 32955 Phone: (321) 639-4842.

Model SARSA PARTS EXPLOSION





Model SARSA PARTS LIST

1 Stock Assembly
2 Stock
3 Stock Screw Washer
4 Bolt Buffer Pad
6 Receiver
7 Trigger Plate Pin (x2)
8 Magazine Shell Latch Pin - A
9 Magazine Shell Latch Pin - B
10 Locking Block
11 Firing Pin
12 Firing Pin Spring
13 Bolt
14 Bolt Slide
15 Firing Pin Retaining Pin
16 Extractor
17 Extractor Plunger
18 Extractor Spring
19 Extractor Pin
20 Forend Rear Support
21 Forend Support Screw (x2)
22 Forend Dowel (x2)
23 Locking Block Shoe
24 Support Chock Absorber
25 Magazine Follower
26 Magazine Spring
27 Magazine Tube
28 Action Spring
29 Magazine Spring Retainer
30 Magazine Cap
31 Complete Barrel Assembly
32 Ejector
37 Front Sight
38 Forend
39 O-Ring
40 Trigger Plate Assembly
41 Trigger Plate
42 Safety Button
44 Trigger
45 Trigger Arm
46 Trigger Arm Pin
47 Trigger Pin
48 Trigger Spring
49 Sear
50 Sear Spring Pin
51 Sear Pin
52 Hammer
53 Hammer Plunger
54 Hammer Spring
55 Hammer Pin
56 Carrier
57 Carrier Dog
58 Carrier Dog Pin
59 Carrier Dog Inner Pin
60 Carrier Dog Follower
61 Carrier Dog Follower Spring
62 Trigger Plate Pin Bushing (x2)
63 Trigger Plate Pin Bushing Spring (x2)
64 Safety Button Spring
65 Safety Button Spring Follower
66 Safety Button Spring Retaining Pin
67 Automatic Safety Lever
68 Automatic Safety Spring
69 Bolt Handle
70 Bolt Handle Spring
71 Action Bar
72 Action Bar Retaining Spring
73 Action Bar Sleeve
74 Piston Assembly
75 Piston
76 Piston Compression Ring
77 Compression Ring Retaining Spring
78 Plug
79 Choke Tube Wrench
80 Choke Tube
81 Stock Connection Screw
82 Carrier Lock
83 Carrier Lock Pin
84 Carrier Lock Pin Spring
85 Magazine Shell Latch
86 Action Release Button
87 Magazine Shell Latch Spring
88 Magazine Shell Latch Spring Pin
89 Action Release Button Pin
90 Action Release Button Spring
91 Recoil Pad Screw (x2)
92 Pistol Grip Cap Screw
93 Butt Plate Frame
94 Recoil Pad
95 Pistol Grip Cap
96 Stock Screw Lock Washer
97 Stock Screw

⚠ WARNING

Children are attracted to and can operate firearms that can cause severe injuries or death.
Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.

⚠ ADVERTENCIA

A los ninos los atroen las armaside de fuego y los pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerte.
Evite que los ninos tengon acceso a los armas de fuego guardandolas siempre con llave y descargadas cuando no las este utilizando. Si usted tiene un arma de fuego cargado en un lugar en que un nono tiene acceso a ella y la usa indebidamente. Le pueden dar una multa a enviarlo a la carcel.

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Rockledge, FL 32955
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Fax: 321-639-7006

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